

Date: Thursday, 1/17/2008 3:23:50 PM
 Kim Johnston

Process Sheet

SP218

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT
 Job Number : 36811A
 Estimate Number : 10452
 P.O. Number :
 This Issue : 1/17/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL / MED FAB
 Previous Run : 36119A
 Part Number : D32781
 Drawing Number : D3278 REV. C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 1/24/2008 Qty: 42 Um: Each
 Written By :
 Checked & Approved By : Handwritten Signature
 Comment : Est: A 04.04.19 New issue KJ/JLM
 est B 07.09.06 rev.c dwg EC verified by: JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total: 10.3062 f(s) ~~45.1536 f~~ 55.9512 f
 Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
 (M6061T6B1.000x02.000) Batch: M106563 x 21.5 ft
m105817 x 30 ft

M1071130 x 15 ft

5.00 ft m107129
~~4.45~~ C26862115

2.0 SHEAR SHEAR



Comment: SHEAR
 Cut blank: 2.00" x 1.00" x 2.550" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA405 and Dwg D3278
 2- Deburr and Tumble
 Identify as D3278-1

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

1.1 ISSUE P/O: 5655
GLOBUS.

C268/02/08 (228)

C 8/3/19 (187)

1.2 RECEIVING AND ATTACHMENT CERT
Handwritten Signature 8/06/03/19

C 5/3/10 (42)

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Drawing Name: SUPPORT

Job Number: 36811A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HJ

08-03-20

X187

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107005

BR 08-03-25

187

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-25

X187

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 84 overstock

AS 08/03/25

X187

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

187

Job Completion



08-03-26

DART AEROSPACE LTD		Work Order:	36811A
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
R1.00	+/-0.030					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

N/A
06/05/19

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

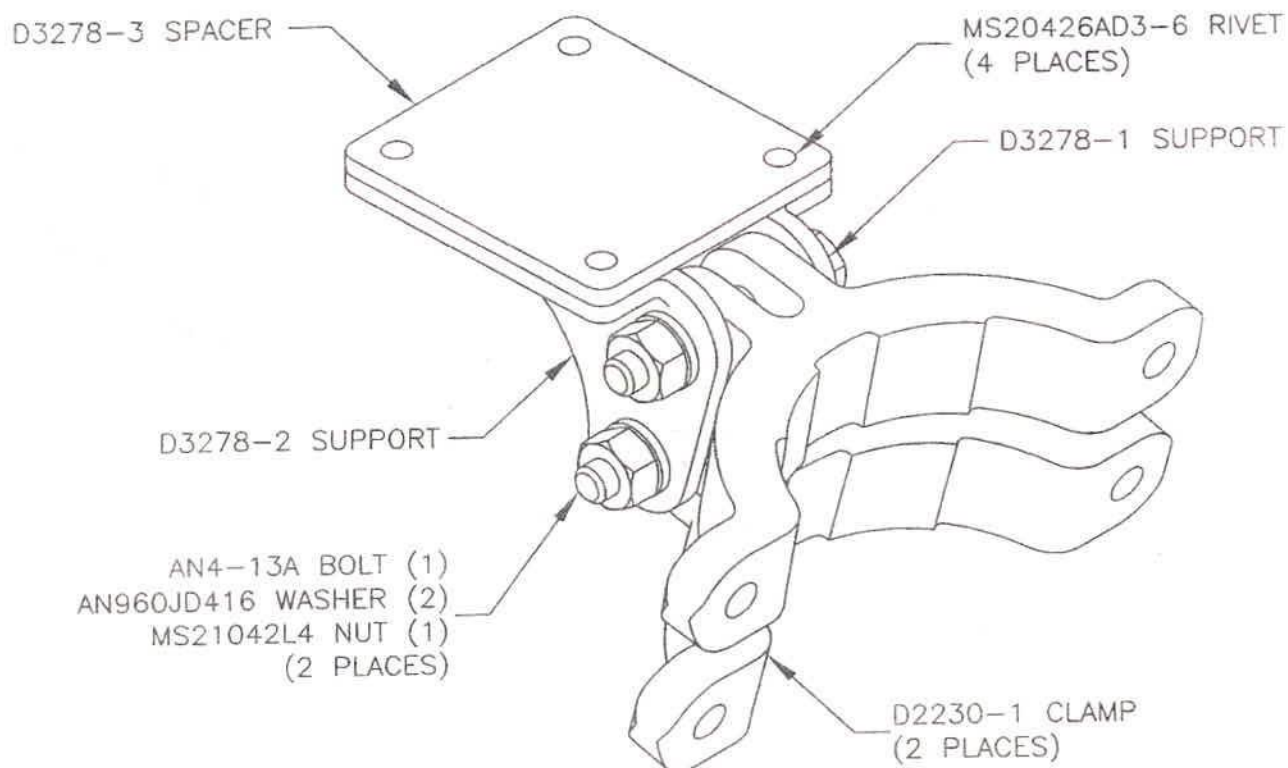
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	



DESIGN 99/	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

SHOP COPY
REVIEW
UNCONTROLLED
SUBMIT
NO 36811A

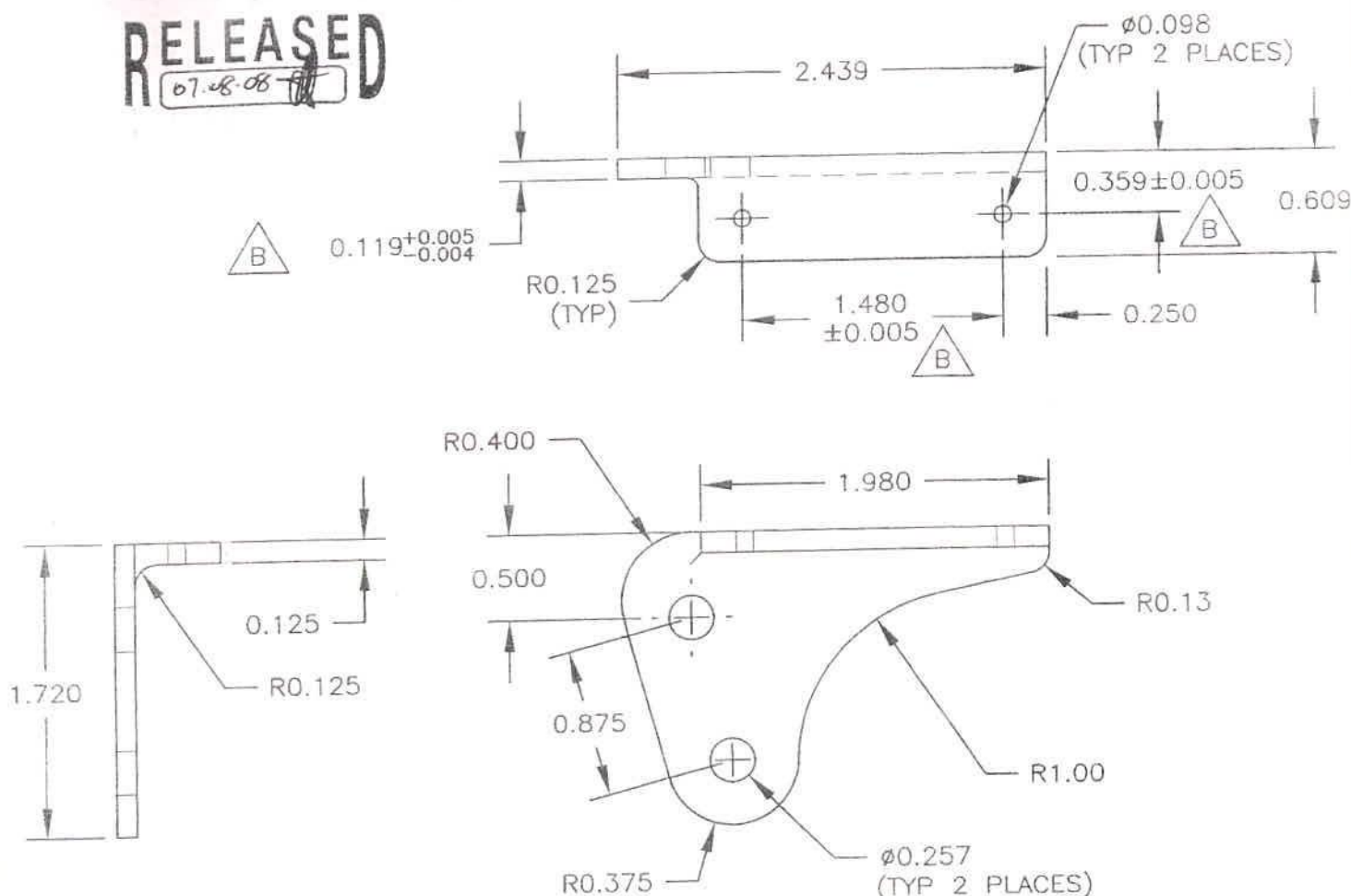
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DESIGN 901	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)
D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

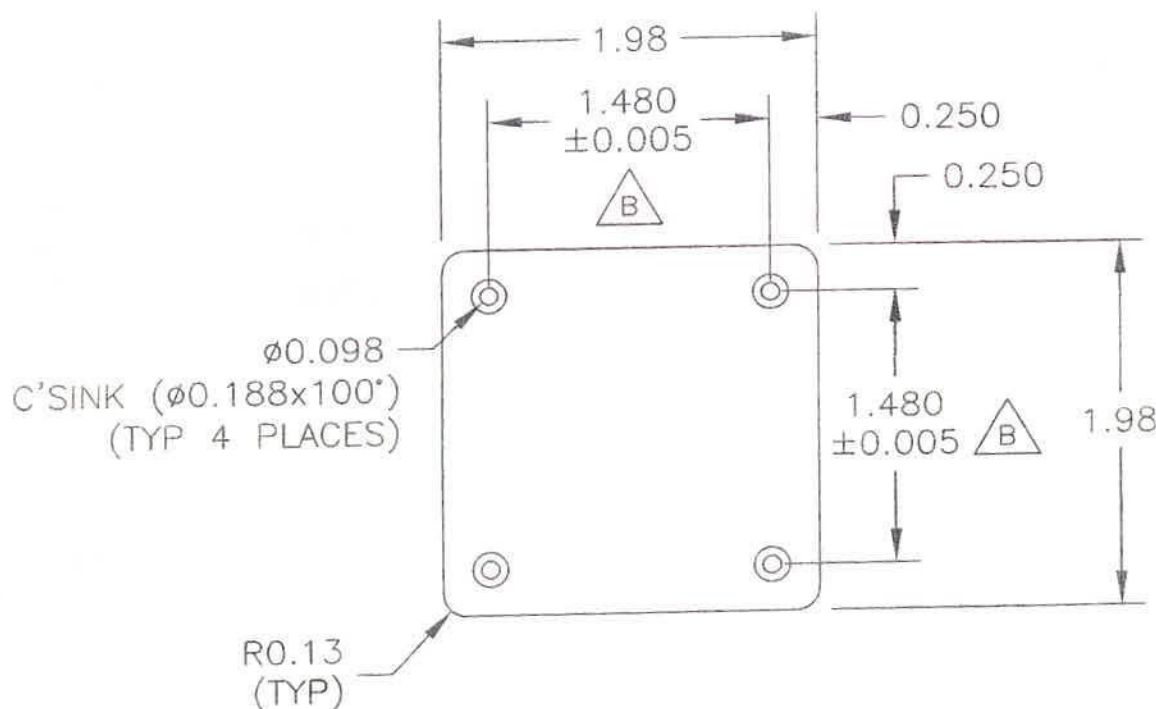
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DESIGN GP	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHIPPING
REWORK
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 36811A

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Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
3/18/2008	17013

BILL TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
000005655	Net 30	3/18/2008	Pick-Up	632	Globus

QTY	DESCRIPTION	RATE	AMOUNT
187	D3278-1 B36811A Support Business Number: 102122058	7.63	1,426.81

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts

GST	71.34
PST	0.00
TOTAL	\$1,498.15